

Work Order ID 124879

124879

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Thursday, September 25, 2014 1:06:49 PM

Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R *OK 9/14/14* Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
 Tri-Bag Float Comp
 Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-09-25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3274-041	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D206-642-541								

N/A MLJ 15-01-14

CHG005

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- remove fwd indexing ridge as per dwg D3274. Prepare for welding

2- weld fwd cap as per dwg D3274 and QSJ004

AR Aluminum Rod Batch: M125127

3- grind fwd cap weld on top surface only

4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

5-Drill Aft cap pilot hole using DT8025

6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274

7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DGC 14-9-26

70614-09-29

DGC 14-9-30

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Accept

N900040100

Setup Start *NS1*

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 9/25/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/25/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID
114

Operation

Description
QC5- Inspect part completeness to step on W/O

**Set Up/
Day Hours**
0.00

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept
Qty

Reject
Qty

Reject Number

Insp.
Stamp

114

QC

Memo

0.00

Quality Control

DAS
9

9-89

116

QC10- Inspect visual per QSI004- ground welds

0.00

1 1 6

QC

Memo

0.00

Quality Control

DAS
9
9-89

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
 Tri-Bag Float Comp
 Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stop
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015.								
	A/RSikaflex-291 <u>129457</u>								
	Sikaflex expire date: <u>14-11-20</u>								
	Start: _____ Time: _____								
	Finish: _____ Time: _____								
	(Adhere for 12 hours)								

① 14-10-1

DGC 14-10-31

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Item ID: D206-642-541**Accept*****N9000040100*****Setup Start *NS1*****Revision ID:** U/R**Item Name:** Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp**Stop *NS2*****Start Date:** 9/25/2014 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 9/25/2014 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:** **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:****Run Start *NR1*****Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170		0.00							
170									
Skidtubes									
	Memo	0.00							
Skidtubes	1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.								
	2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr								
	3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES								
	4- Countersink crossbolt spacer holes as per Dwg D3274								
	5- prepare for welding								

DAS
03
9-28

DP

14-10-02

DGL 14-10-02

DP 14-10-2

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-00
180	QC5- Inspect part completeness to step on W/O	0.00	4.5° 3.0"			1	0	14-10-06		
180										
QC	Memo	0.00								
Quality Control										
190		0.00								
190										
Skidtubes										
	Memo	0.00								
	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod <u>m125127</u>									
	3-Grind cross bolt welds flush as per Dwg D3274. ***INSPECT FOR PIN HOLES IN WELD***									
	4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.									

BE14-10-06
DL 14-10-06
14-10-7

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Revision ID: U/R Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Time	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 16 9-89 14/10/08							
210 *210* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 DAS 16 9-89 14/10/08							
220 *220* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo ✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch	0.00 0.00							14/10/09

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* SprayPaint Spray Painting	Memo Make sure Nut Plate Thread is protected using paint screw, 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>128 975</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>130 308</u>	0.00 0.00				<u>1</u>			<u>CP 14.10.21</u>
240 *240* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				<u>1 x d</u>	<u>all</u>	<u>10/11/10</u>	<u>10/11/10</u>
244 *244* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>11130209</u> Memo	0.00				<u>1 x d</u>	<u>all</u>	<u>10/11/10</u>	<u>10/11/10</u>

DAS
15
9-89

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 38 9-89
246 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>6</u>			<u>14-11-11</u>
250 *250* HandFinish Hand Finishing	HandFinishing Memo	0.00 0.00				<u>12</u>	<u>9</u>	<u>11</u>	<u>4/11/07</u>

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON M122900

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/RSikaflex-291 M130227
Sikaflex expire date: 12/08

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Item ID: D206-642-541 Accept *N900040100* Setup Start *NS1*
Revision ID: U/R Stop *NS2*
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC5- Inspect part completeness to step on W/O	0.00							
260						1	0	4-11-7	24 00
QC	Memo	0.00							
Quality Control	Inspect Nut Plate & Inserts								
270		0.00							
270	HAND FINISHING RESOURCE #1								
HandFinish	Memo	0.00							
Hand Finishing	1-Install wearpads & gaskets as per Dwg D3274.								
	2-Install ring as per Dwg D3274								
	A/RSikaflex-291 <u>MC30277</u>								
	Sikaflex expire date: <u>12/00</u>								
	3-Inspect for foreign objects as per QSI 024								
	4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.								
	A/RSikaflex-291 <u>MC30277</u>								
	Sikaflex expire date: <u>12/00</u>								

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 *280* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			38 9-89 14-11-11
290 *290* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							DAS 05 9-89 JAN 14 2015
300 *300* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MCS 1505-14 MF 15-1-14

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC IPP
 REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I
 14.04.28 AS PER ECN14-520 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3274-041BENT

Manufactured No

110

Each

10.0000

1

1

D3274-041BENT

Skidtube Assembly 206

**

Dec 14-9-26

Location

Loc Qty

Loc Code

LG002

10

113682

1

120287

9

D4956-15

Manufactured No

270

Each

14.0000

1

1

D4956-15

Stainless Steel Wearplate Fwd

**

Dec 14-11-07

Location

Loc Qty

Loc Code

FP002

14

120326

2

122996

12

D4956-23

Manufactured No

270

Each

10.0000

1

1

D4956-23

Stainless Steel Wearplate Center Fwd

**

Dec 14-11-07

Location

Loc Qty

Loc Code

FP002

10

121755

10

1

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D4956-35 Manufactured No

270 Each

Start Qty: 1.00
12.0000 1 1

Required Qty: 1.00

D4956-35

Stainless Steel Wearplate Aft

**

all 12/10/07

Location

Loc Qty

Loc Code

FP002

12

120577

1

121975

11

D4956-39 Manufactured No

270 Each

9.0000 1

D4956-39

Stainless Steel Wearplate Center Aft

**

all 12/10/07

Location

Loc Qty

Loc Code

FP002

9

121857

9

D3285-1 Manufactured No

110 Each

5.0000 1

D3285-1

Cap

**

8614-09-29

Location

Loc Qty

Loc Code

LG001

5

108052

5

D3282-041 Manufactured No

150 Each

7.0000 1

D3282-041

Float Web (206L/407)

**

Doc 14-10-01

Location

Loc Qty

Loc Code

LG002

7

113149

1

119524

6

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Parent Item: D206-642-541

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Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D2649

Manufactured No

190 Each

415.0000 12 12

Required Qty: 1.00

D2649

Cross Bolt Spacer

**

BE14-10-03

Location

Loc Qty

Loc Code

LG

203

123099

203

12

LG001

212

107906

3

112728

6

113811

2

120508

195

90497

6

D3275-1

Manufactured No

190 Each

191.0000 12 12

D3275-1

Crossbolt Spacer

**

BE14-10-03

Location

Loc Qty

Loc Code

LG001

191

113246

1

113851

62

144877

65

12

121868

1

121974

62

CR3212-4-03

Purchased No

250 Each

998.0000 2 2

CR3212-4-03

Cherry Rivet

**

BE14-10-03

Location

Loc Qty

Loc Code

ST321

998

114889

1

119017

700

m114859

100

m123265

197

KZ

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Parent Item: D206-642-541

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Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3415-041	Manufactured	No	250	Each	19.0000	Start Qty: 1.00 1	Required Qty: 1.00 1
D3415-041						**	all 10/11/07
Nut Plate							

	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	ST037		19				
	113764		19				X1
CCR264SS3-3	Purchased	No	250	Each	431.0000	2	2
CCR264SS3-3						**	all 10/11/07
Cherry Rivet							

	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	ST321		431				
	113973		26				
	m126282		47				
	m126333		70				X2
	m128636		88				
	m128818		200				
ALS4-1032-130	AELS4-1032-130	Purchased	250	Each	4,073.000	78	78
AI S4-1032-130						**	all 10/11/07
Rivnut							

	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	ST267		4073				
	M126109		57				
	M128211		48				
	M128649		3968				X78

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Parent Item: D206-642-541

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Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3537-3

Manufactured No

270

Each

60.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D3537-3

Wearpad

lll w/ulog

Location

Loc Qty

Loc Code

FG

8

86237

8

FP001

12

111825

1

113789

1

115122

10

x1

FP002

40

120646

40

D3537-1

Manufactured No

270

Each

78.0000

9

9

D3537-1

Wearpad

lll 14/11/07

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

B125 679

x9

FP001

60

113839

4

120644

37

120645

18

93945

1

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3672-1

Manufactured No

270

Each

Start Qty: 1.00
955.0000 2 2

Required Qty: 1.00

D3672-1

Washer, Phenolic

**

all 10/1/07

Location

Loc Qty

Loc Code

FG	10	
85222	10	
ST055	945	
103845	4	
113581	474	
120116	421	
80369	34	
99099	12	

x2

AN3C4A

Purchased No

270

Each

1,103.000 80 80

AN3C4A

Bolt

**

all 10/1/07

Location

Loc Qty

Loc Code

FG	20	
122814	20	
ST350	1083	
124221	12	
M127410	1	
M127832	62	
M128606	32	
M128634	8	
M128739	4	
M128879	71	
M129520	893	

x80

Picklist Print

Thursday, September 25, 2014 1:06:53 PM

Page 8

Work Order ID: 124879

124879

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

AN4C5A

Purchased

No

270

Each

56.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

AN4C5A

Bolt

**

all 9/25/14

Location

Loc Qty

Loc Code

ST355

56

122599

3

123265

1

M127410

10

M128403

42

x1

D2646

Manufactured

No

270

Each

57.0000

1

1

D2646

Aft Cap

**

all 9/25/14

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

12

103306

2

107857

1

110816

1

113830

2

114495

6

FP002

41

119656

41

x1

Picklist Print

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Page 9

Work Order ID: 124879

124879

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3413-1

Manufactured No

270

Each

33.0000

Start Qty: 1.00

Required Qty: 1.00

1

1

D3413-1

O-Ring

all 9/25/14

Location

Loc Qty

Loc Code

ST525

33

106048

1

110715

11

112309

6

114489

3

114528

1

116664

1

120218

10

XL

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D4956-15	WEARSHOE
1	1	D4956-23	WEARSHOE
1	1	D4956-35	WEARSHOE
1	1	D4956-39	WEARSHOE
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN860C416	WASHER
80	80	AN860C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB
- PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
- BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES 0.005 TO 0.010 MAX
6. IDENTIFICATION: N/A
7. WEIGHT: 20.8 LBS
8. WELDING TO BE DONE PER DART QSI 004.
9. ALL HOLES DRILLED ON CENTERLINES.
10. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11. BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.

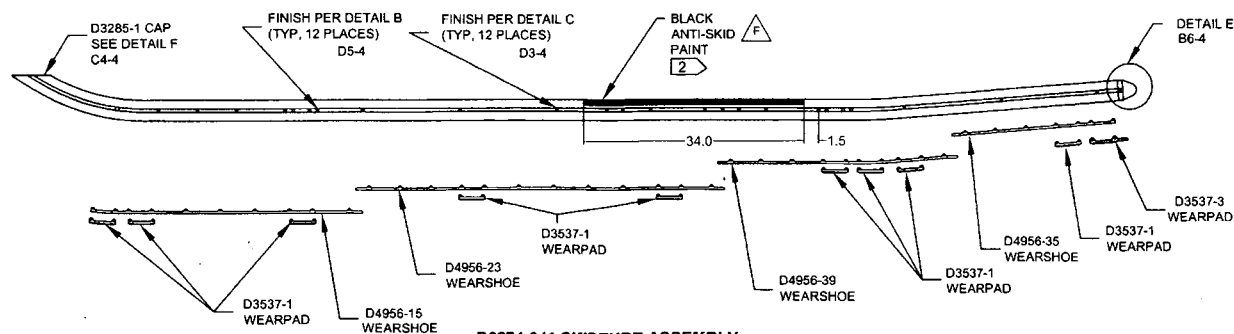
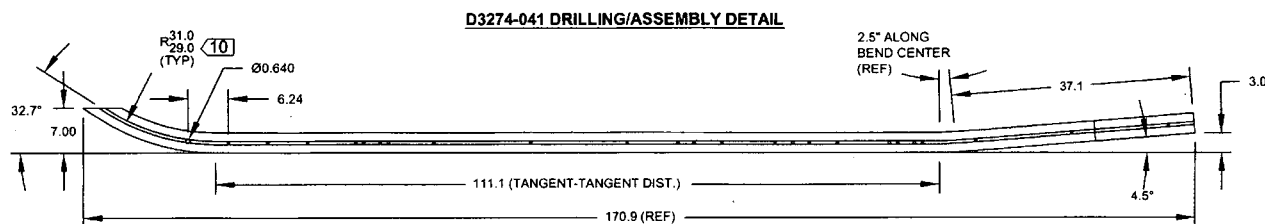
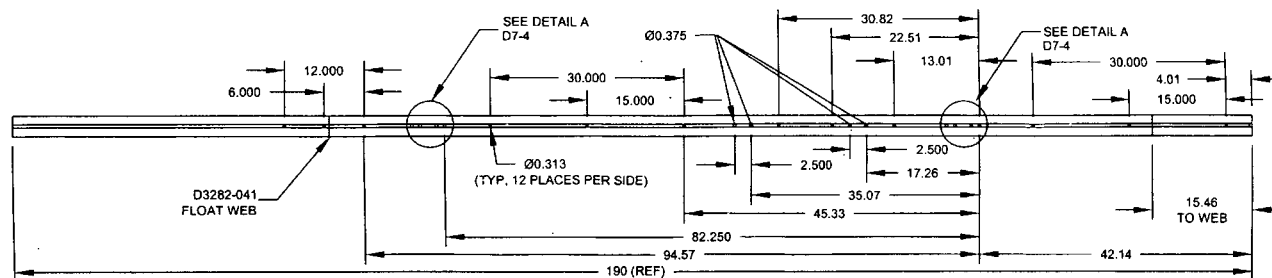


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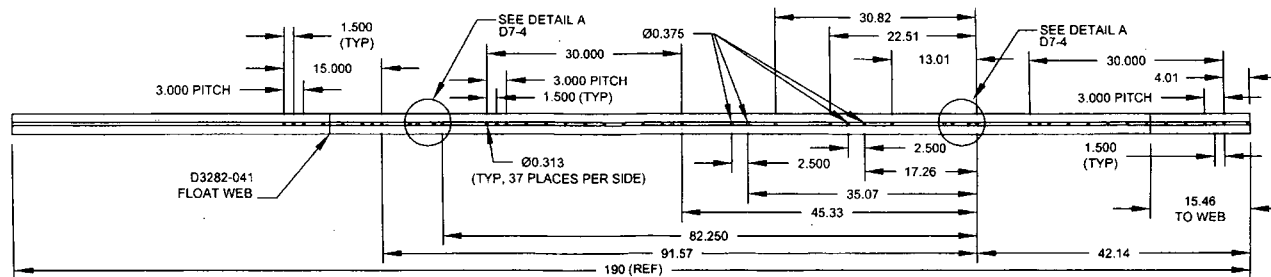
RELEASED
2014-05-26
WD

F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D208-842 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
C	ADD -043; NEW INSERTS	CP	05.03.16
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	DE	DRAWING NO.	REV. F
MFG. APPR.	DE	D3274	SHEET 1 OF 4
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	SKIDTUBE ASSEMBLY	NTS
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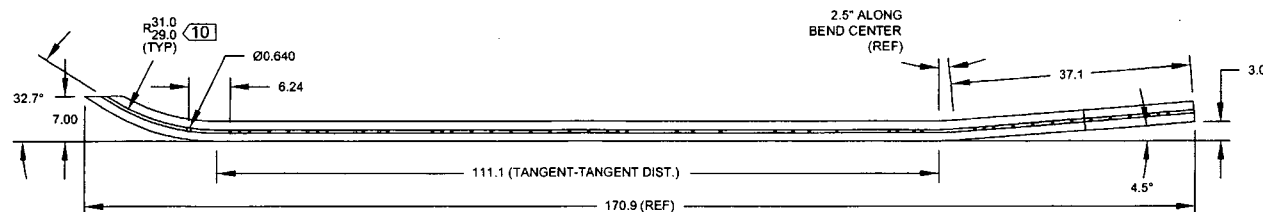


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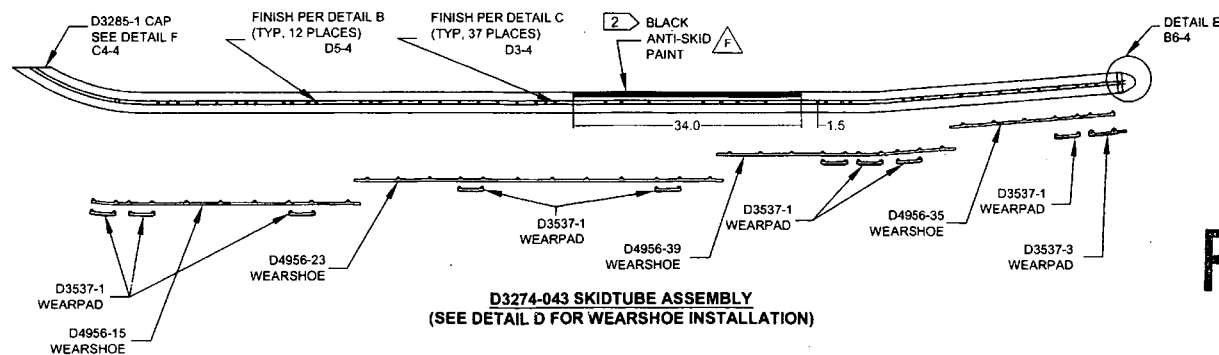
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DRAWN	DB	KENT, WA	
CHECKED	<i>DB</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>DB</i>	D3274	SHEET 2 OF 4
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D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL

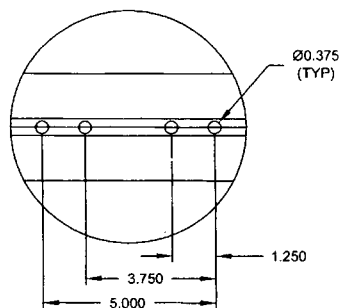


**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

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2014-05-26

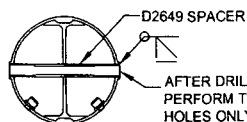
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CHECKED	<i>DB</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3274	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE ASSEMBLY	4.04.15
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DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

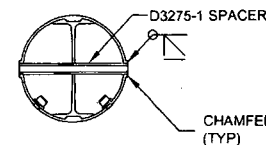
FOR Ø0.375 HOLES ONLY



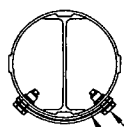
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



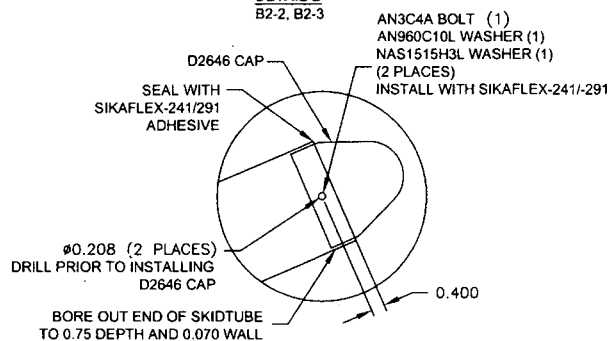
DETAIL D
A4-2, A4-3



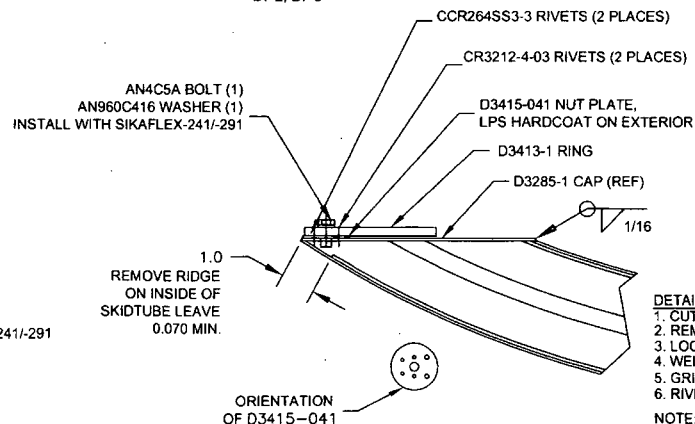
ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASE
2014-05-26

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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